

Work Order ID 115342

March-26-14 10:19:36 AM

115342

Page 1

Item ID: D3536-13

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Gasket Fwd

Start Date: 3/26/14 Start Qty: 8.00

8 / 2
8

Cust Item ID:

Required Date: 4/09/14 Req'd Qty: 8.00

Customer:

Reference:

Approvals: Process Plan: MVS

Date: 14-03-26 Tooling:

Date: _____

Run Start

NR1

QC: _____

Date: _____ SPC (Y/N): _____

Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3536	Rev A

100 0.00

100

FLOW WATER JET

Waterjet

Memo 0.00

12 mm / 2 14/04/01

FLOW-CNC Waterjet

1-Cut as per Dwg D3536 Dwg Rev: D3536 Prog Rev: A 2-
Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB 0.00

110

QC

Quality Control

Memo 0.00

12 mm / 2 14/04/01

120

QC8- Inspect parts - second check 0.00

120

QC

Quality Control

Memo 0.00

DAS
27
9.8%
14/4/2

12

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Page 2

Item ID: D3536-13

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Gasket Fwd

Stop

NS2

Start Date: 3/26/14 **Start Qty:** 8.00

8

Cust Item ID:

Required Date: 4/09/14 **Req'd Qty:** 8.00

8

Customer:

Reference:

Approvals:	Process Plan: _____	Date: _____	Tooling: _____	Date: _____	Run	Start	*NR1*
	QC: _____	Date: _____	SPC (Y/N): _____	Date: _____	Stop		*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Packaging	Identify as per dwg & Stock Location: <u>FPO01</u>	0.00							DAS 28 989
Packaging	Memo	0.00							APR 03 2014

140

QC21- Final Inspection - Work Order Release 0.00

140

QC

Quality Control

Memo

0.00

R14-04-3
PL 14-04-03

Picklist Print

Page 1

March-26-14 10:19:39 AM

Work Order ID: 115342

115342
D3536-13

Parent Item: D3536-13

Parent Item Name: Gasket Fwd

Start Date: 3/26/14

Required Date: 4/09/14

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MNEO60S.063		Purchased	No			100	sf	1,120.100	0.8269	8	**	mm 14/04/01	

MNEO60S.063

NEOPRENE SHEET 0.063

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT052	1120.1	
M126546	27.1	
M128266	293	9.3
M128339	800	

DART AEROSPACE LTD	Work Order:	115342
Description: Gasket	Part Number:	D3536-13
Inspection Dwg: D3536	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

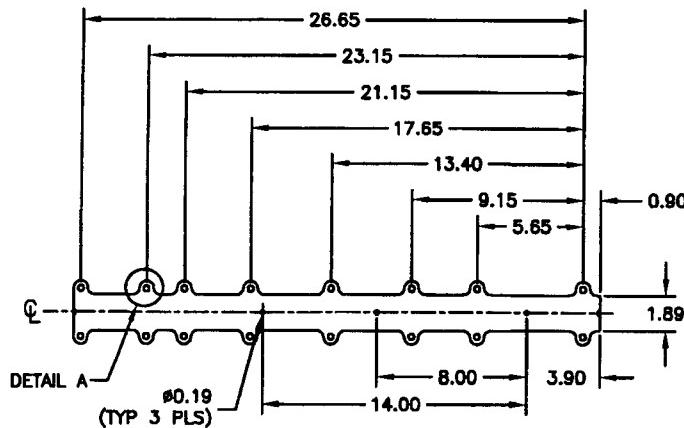
X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
32.90	+/-0.030	32.90	✓		T	Jkm-07
29.40	+/-0.030	29.40	✓		T	
27.40	+/-0.030	27.40	✓		T	
23.90	+/-0.030	23.90	✓		T	
18.98	+/-0.030	18.98	✓		T	
14.07	+/-0.030	14.07	✓		T	
9.15	+/-0.030	9.15	✓		T	
5.65	+/-0.030	5.65	✓		V	Jkm-05
3.90	+/-0.030	3.90	/		✓	
8.00	+/-0.030	8.00	✓		T	
14.00	+/-0.030	14.00	✓	T	T	
20.00	+/-0.030	20.00	✓		T	
1.89	+/-0.030	1.90	✓		V	
0.30	+/-0.030	0.30	✓		V	
0.30	+/-0.030	0.30	✓		V	
Ø0.19	+0.005/-0.001	0.19	✓		✓	

DAS

Measured by:	<u>mm / EL</u>	Audited by:	<u>27</u> <u>9.80</u>	Prototype Approval:	N/A
Date:	<u>14/04/08</u>	Date:	<u>14/4/08</u>	Date:	N/A

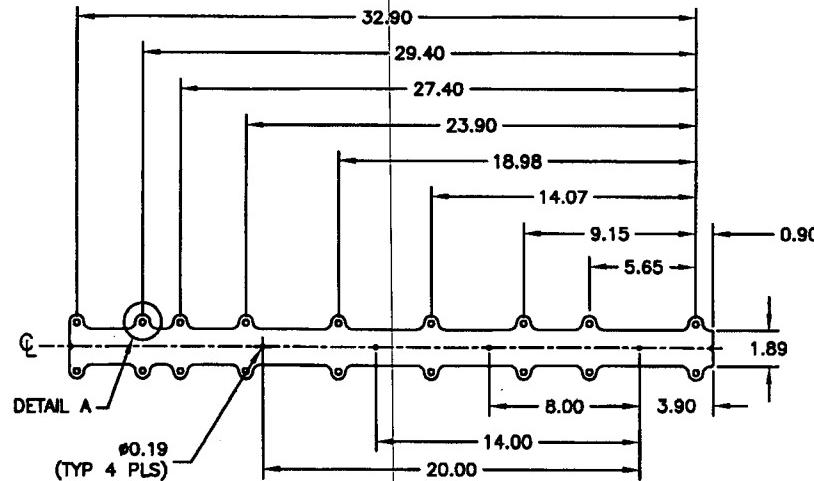
Rev	Date	Change	Revised by	Approved
A	07.06.13	New Issue	KJ/JLM	EE



D3536-11 GASKET

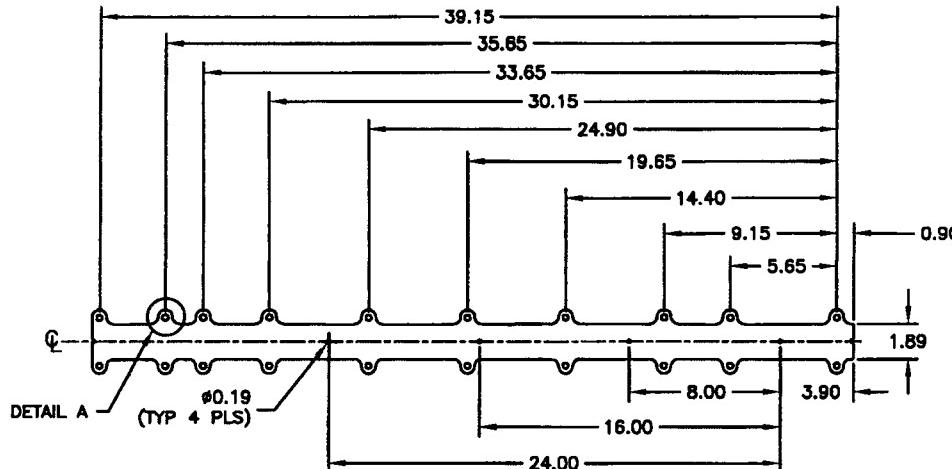
115342 MLJ
14-03-26

09.02.12-
RELEASED



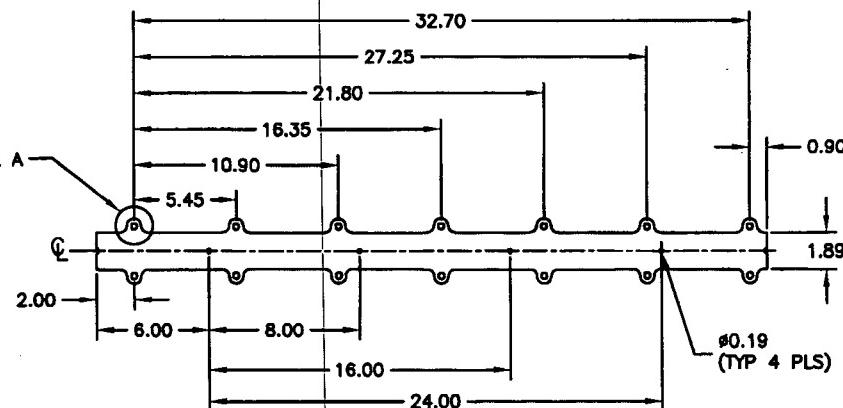
D3536-13 GASKET

DESIGN CB	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED PH	APPROVED SH	DRAWING NO. D3536
DATE 06.10.25		SCALE 1:10
A	06.10.25	NEW ISSUE



D3536-15 GASKET

- NOTES**
- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
 - 2) FINISH: NONE
 - 3) PART IS SYMMETRICAL ABOUT $\frac{C}{2}$
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 5) ALL DIMENSIONS ARE IN INCHES
 - 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
 - 7) SEE PAGE 6 FOR DETAILS AND SECTION

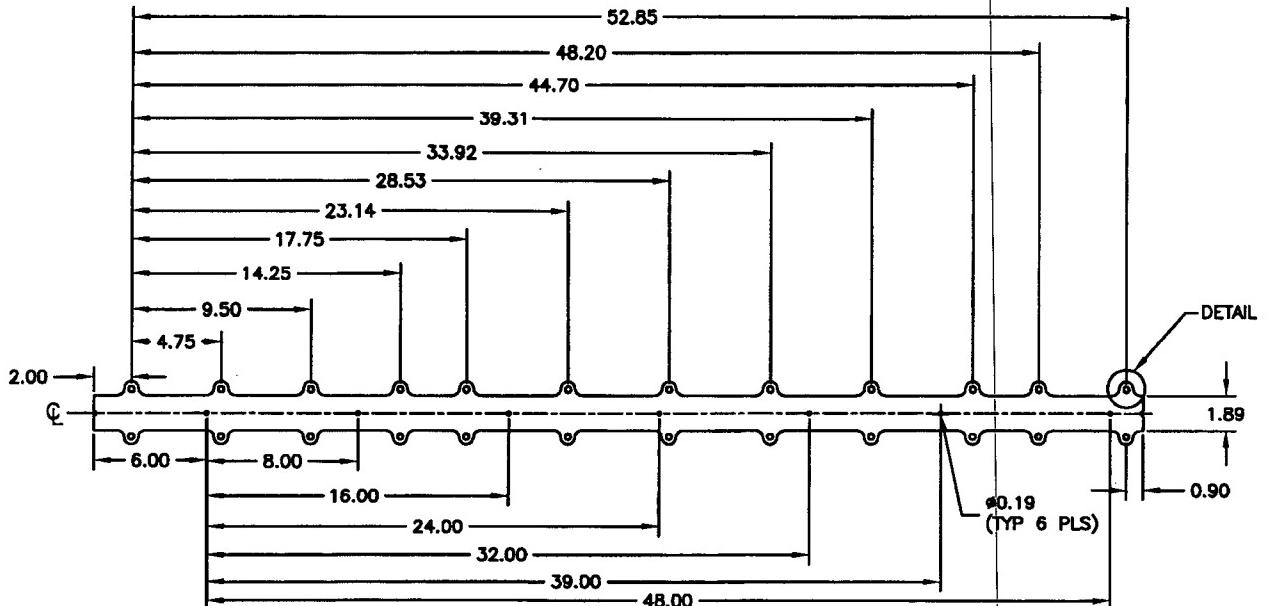


D3536-21 GASKET

DESIGN CB	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED <i>MH</i>	APPROVED <i>MH</i>	DRAWING NO. D3536
DATE 06.10.25	TITLE GASKET	REV. A SHEET 2 OF 6 SCALE 1:10

RELEASER
07.02.12

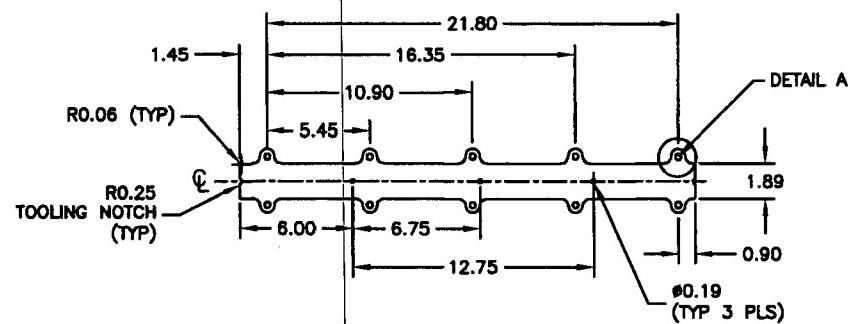
DART



D3536-23 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE060-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT $\frac{1}{4}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

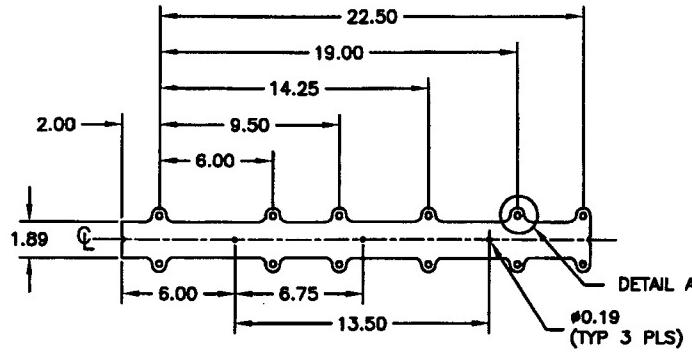


D3536-25 GASKET

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
C.B	C.B	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
PW	SM	D3536
DATE		TITLE
06.10.25		GASKET
		SCALE
		1:10
		REV. A
		SHEET 3 OF 6

DART

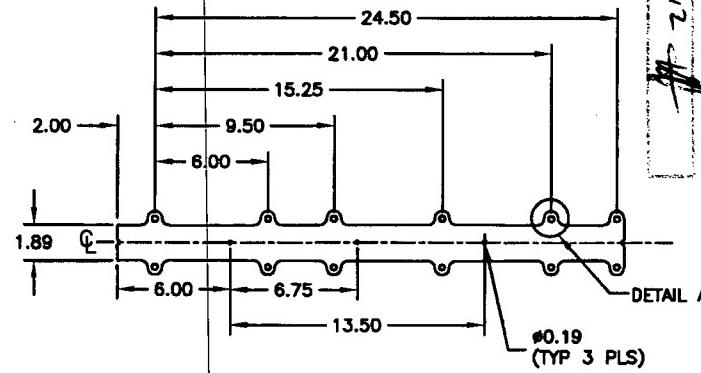
07-02-12
JL



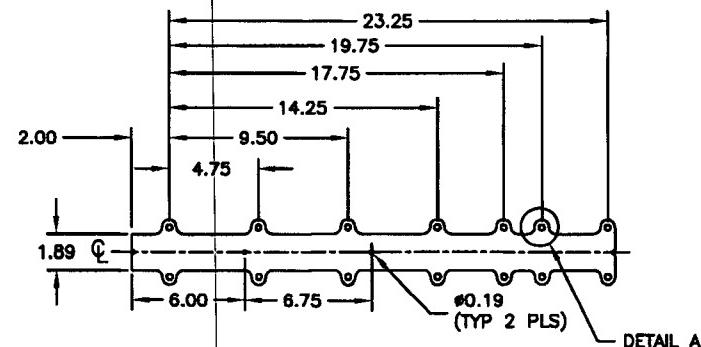
D3536-31 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT $\frac{1}{2}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION



D3536-33 GASKET



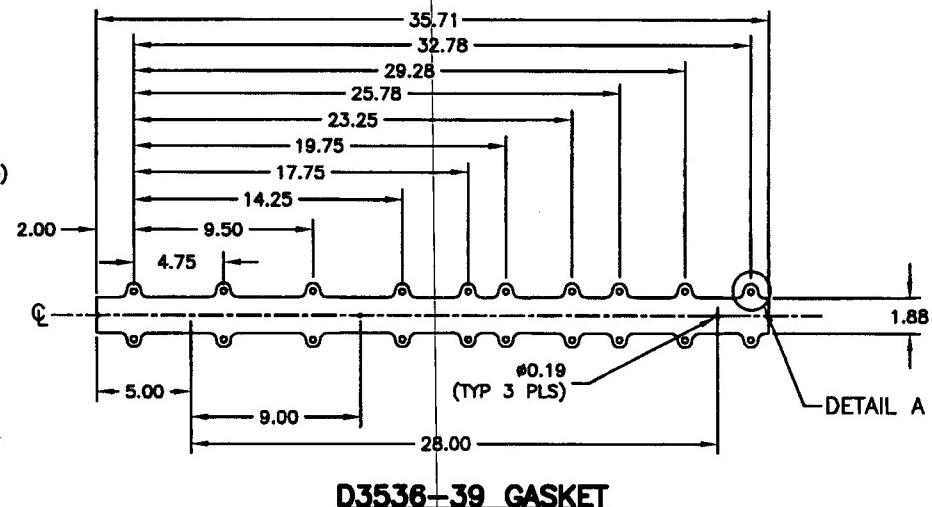
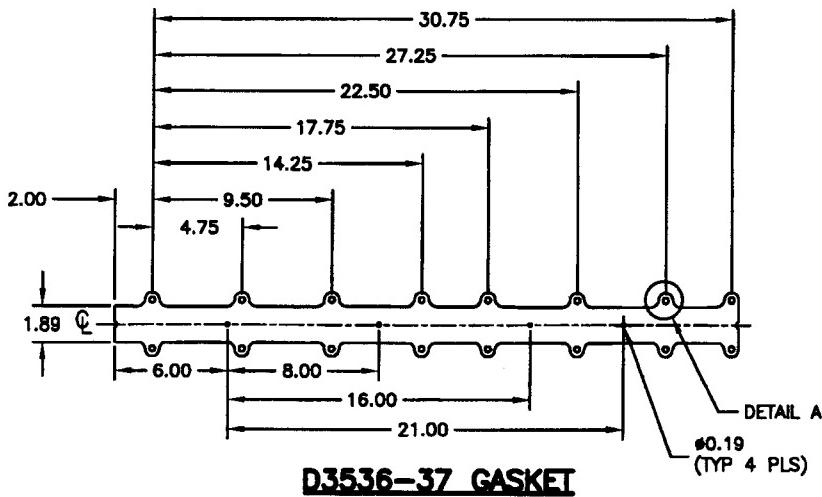
D3536-35 GASKET

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
C.B	C.B	P.O. PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
MH	MH	D3536
DATE		TITLE
06.10.25		GASKET
		REV. A
		SHEET 4 OF 6
		SCALE
		1:10

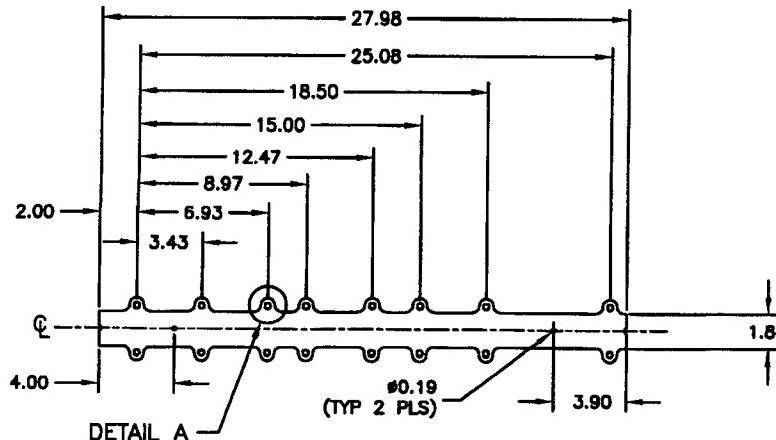
DART

DART

DESIGN CB	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED M	APPROVED M	DRAWING NO. D3536
DATE 06.10.25	TITLE GASKET	REV. A SHEET 5 OF 6 SCALE 1:10

07.02.12
[Signature]**NOTES**

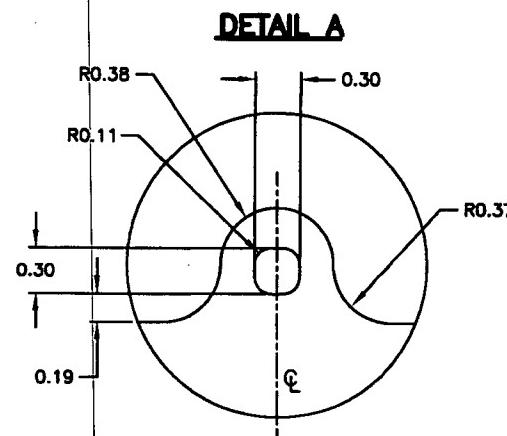
- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT $\frac{1}{4}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION



D3536-41 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT $\frac{C}{4}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER



DESIGN CB	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED <i>PH</i>	APPROVED <i>PH</i>	DRAWING NO. D3536
DATE 06.10.25		SHEET 6 OF 6 TITLE GASKET SCALE 1:10

DART

07.02.12 *PH*